

Work Order ID 132026

Thursday, April 23, 2015 10:17:10 AM

These
132026

May 1st
DUST
Page 1

Item ID: D3796-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Wearplate Weldment

Start Date: 4/23/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/1/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: UNF

Date: 5-4-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3796	B

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3796 Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

(2)

02/15/04/24

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(2)

02/15/04/24

Thursday, April 23, 2015 10:17:10 AM

Page 2

**DAS
24
9-89**

Work Order ID 132026***132026***

Page 3

Thursday, April 23, 2015 10:17:10 AM

Item ID: D3796-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Wearplate Weldment

Start Date: 4/23/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/1/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>PP131658</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

2 MAY 01 2015 DAS 24 9-89

2 DAS 6 MAY 01 2015 9-89

MCS MAY 04 2015

MCS MAY 04 2015

Picklist Print

Page 1

Thursday, April 23, 2015 10:17:10 AM

Work Order ID: 132026

132026

Parent Item: D3796-043

D3796-043

Parent Item Name: Aft Wearplate Weldment

Start Date: 4/23/2015

Required Date: 5/1/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-08-05 new issue DD verified by:ec
IPP Rev:B 08-09-10 revA as per dwg (ecn 08-513) DD VERF:EC IPP REV:C
AS PER PB1 12-07-04 JLM VERIFIED BY:DD IPP REV:D
12.09.06 PER DWG REV.B DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4379-3		Manufactured	No			130	Each	41.0000	12	24			
---------	--	--------------	----	--	--	-----	------	---------	----	----	--	--	--

D4379-3

Wearplate Cup

**

15-04-29
JMCLocationLoc QtyLoc Code

WA002	131657	41	
	119018	1	
	130221	40	

24

M304S16GA

Purchased No

100 sf

368.9176 1.912

5

M304S16GA

304/316 Sheet .063

**

02/15/04/24

LocationLoc QtyLoc Code

MAT019

368.9176

m131384

144.9176

m131503

224

5.2

8 7 6 5 4 3 2 1

D

D

C

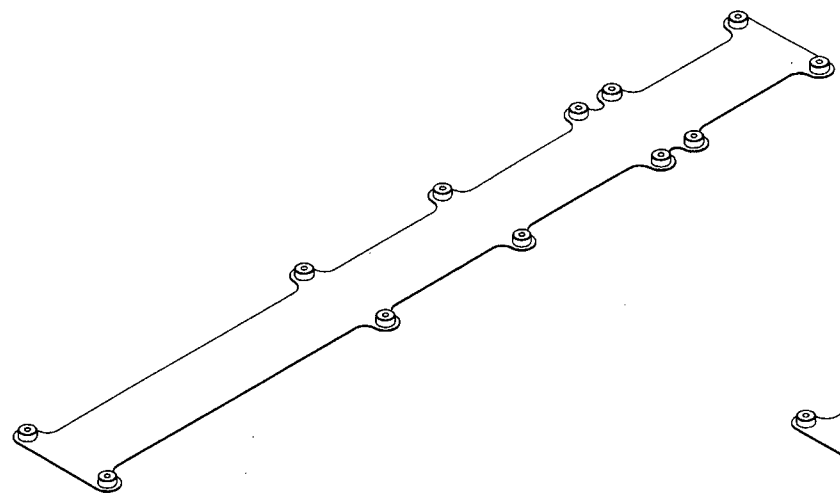
C

B

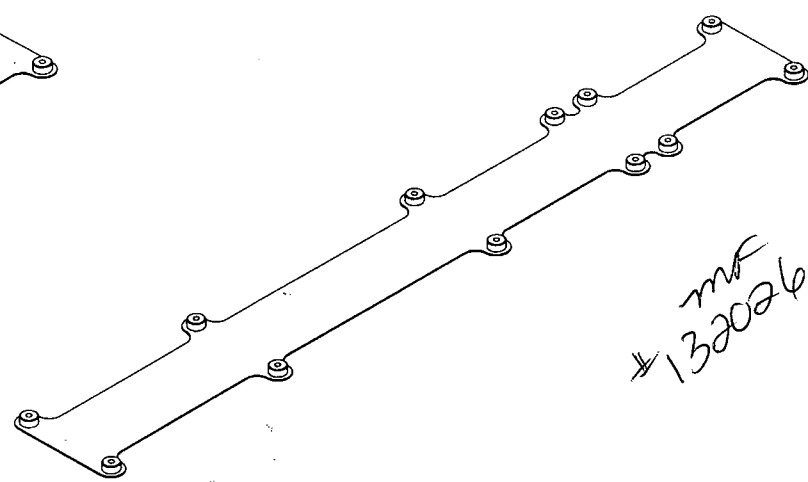
B

A

A



D3796-041 FWD WEARPLATE WELDMENT



D3796-043 AFT WEARPLATE WELDMENT

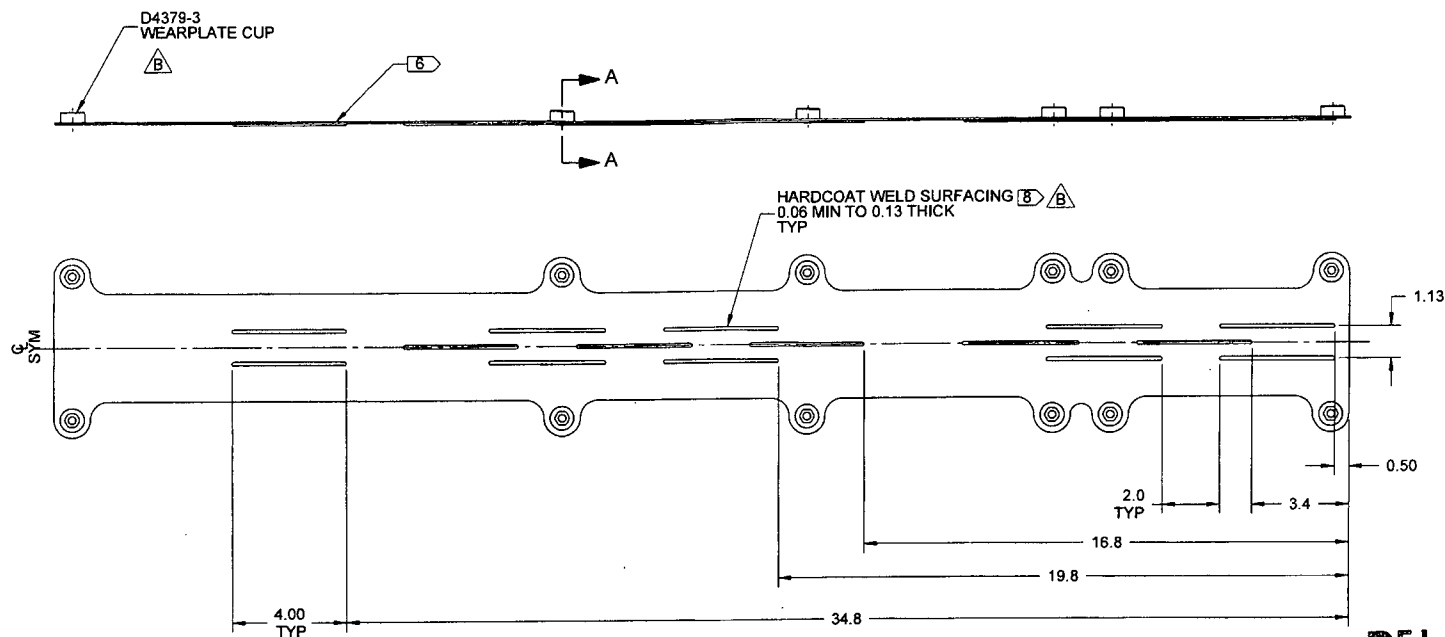
*mf
132026*

RELEASED
2012-08-10

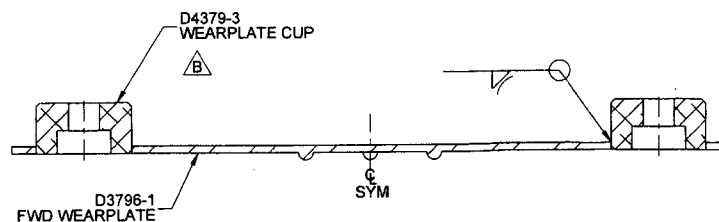
B	REPLACED D3009-3 CUP WITH D4379-3 WEARPLATE CUP; REMOVE REFERENCE TO 2059 HARDCOAT WELD SURFACING TO ALLOW ALTERNATIVE HARDCOAT MATERIALS PER QSI 004 (C4-2 & C5-3); REMOVE POWDER COAT FINISH NOTE 2 (SHEETS 2 & 3)		AP	12.07.04
A	NEW ISSUE		MB	08.08.01
REV.	DESCRIPTION		BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AP			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3796	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		412 SKI WEARPLATE	NTS	
DATE	12.07.04		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

QTY -041	P/N	DESCRIPTION
X	D3796-041	FWD WEARPLATE WELDMENT
1	D3796-1	FWD WEARPLATE
12	D4379-3	WEARPLATE CUP



D3796-041 FWD WEARPLATE WELDMENT



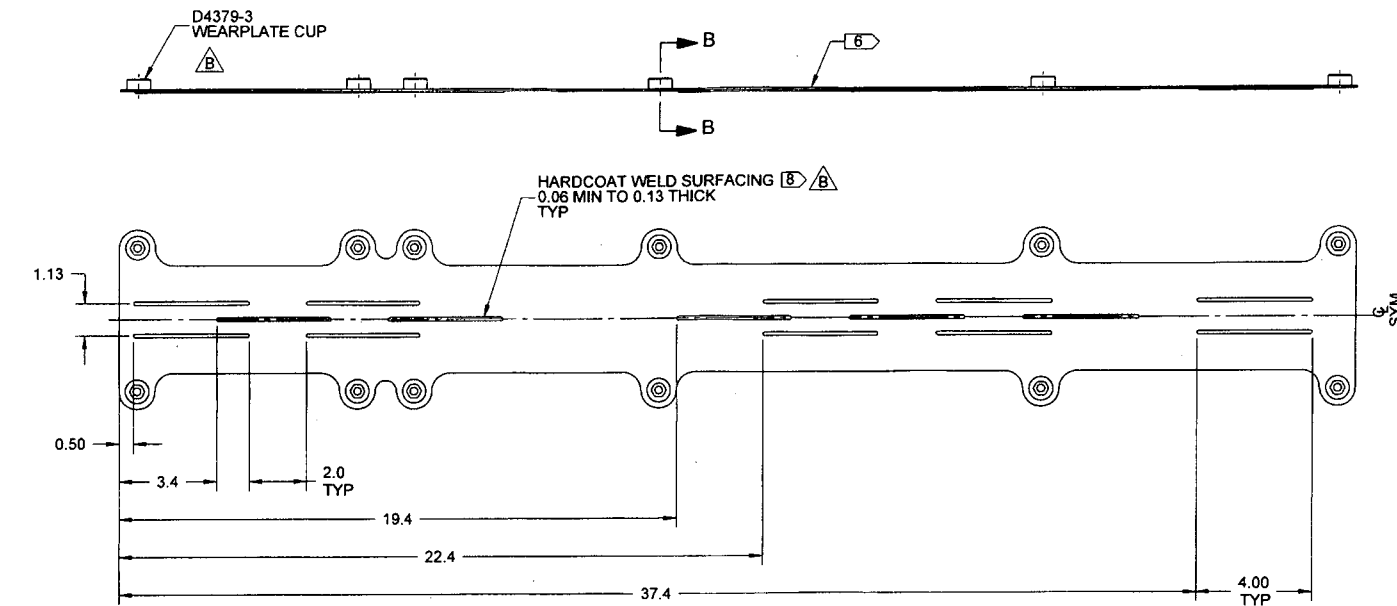
**SECTION A-A D5-2
SCALE 4X, TYP**

RELEASED
2012-08-10
JMP

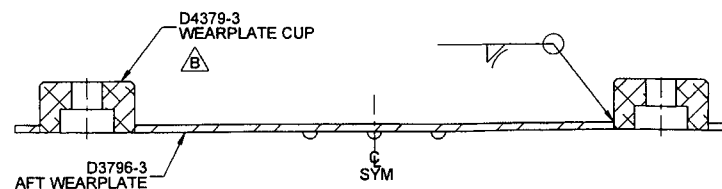
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3796-041" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER PER QSI 044
 - 7) WEIGHT: 4.00 lbs
 - 8) WELD PER DART QSI 004

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JS	D3796	SHEET 2 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	412 SKI WEARPLATE	NTS
DATE	12.07.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

QTY -043	P/N	DESCRIPTION
X	D3796-043	AFT WEARPLATE WELDMENT
1	D3796-3	AFT WEARPLATE
12	D4379-3	WEARPLATE CUP



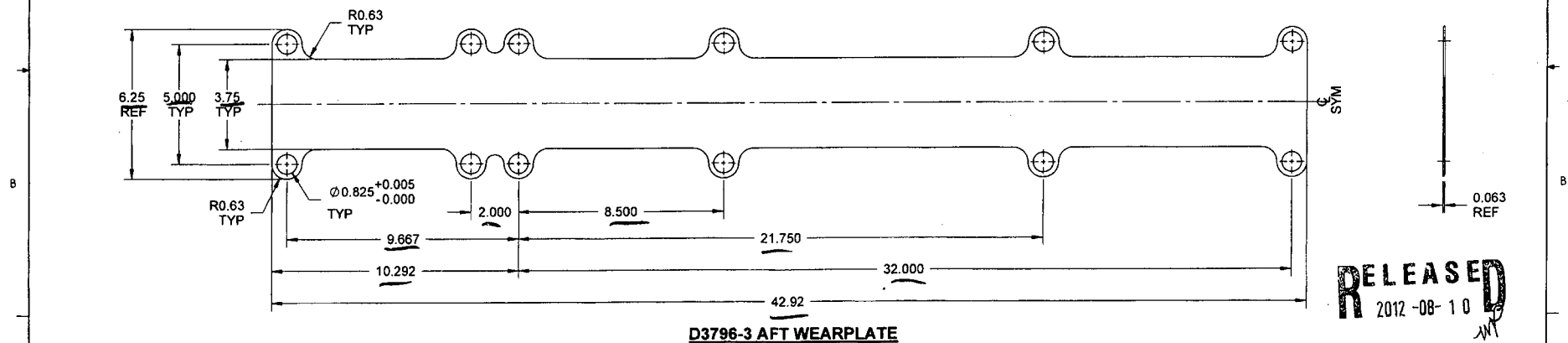
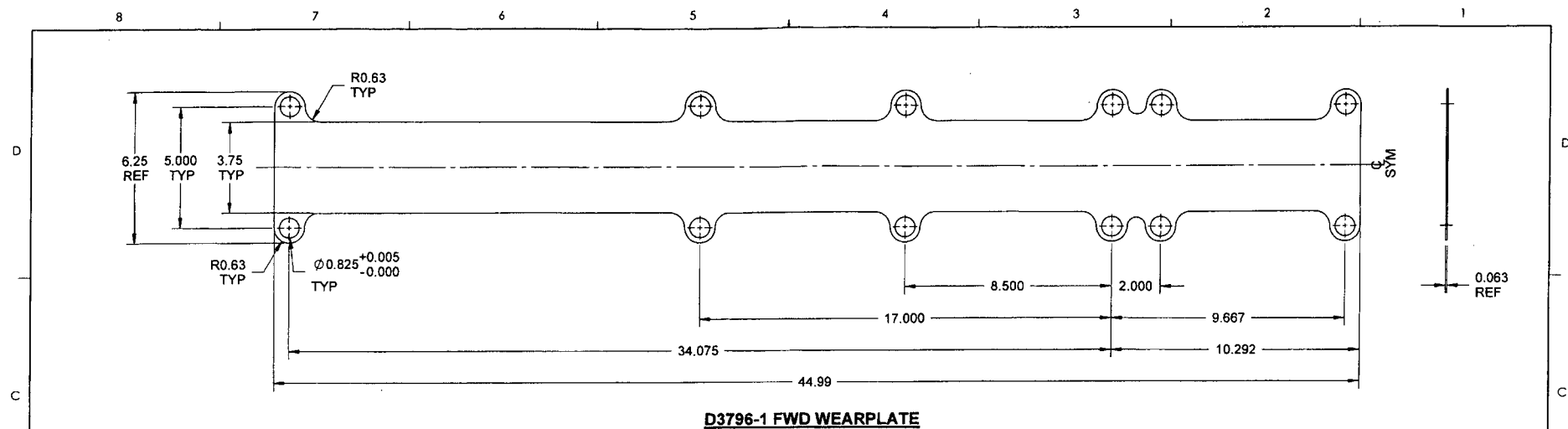
D3796-043 AFT WEARPLATE WELDMENT



SECTION B-B D5-3
SCALE 4X, TYP

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3796-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER PER QSI 044
 - 7) WEIGHT: 3.86 lbs
 - 8) WELD PER DART QSI 004

DESIGN	MB	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA DRAWING NO. D3796 TITLE 412 SKI WEARPLATE COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT AND ITS CONTENTS ARE UNCLASSIFIED AND IN THE PUBLIC DOMAIN. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY OTHER FORM WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. B
DRAWN	AP		SHEET 3 OF 4
CHECKED			SCALE
MFG. APPR.			NTS
APPROVED			
DE APPR.			
DATE	12.07.04		



RELEASED
2012-08-10

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, (ANNEALED) 2B FINISH, 16 GAUGE (0.063 THICK) PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240, REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3796-1 = 3.37 lbs
D3796-3 = 3.11 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HP	DRAWING NO.	REV. B
MFG. APPR.	DS	D3796	SHEET 4 OF 4
APPROVED	HP	TITLE	SCALE
DE APPR.	HP	412 SKI WEARPLATE	NTS
DATE	12.07.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

